



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5951
Job Sheet 173832



Part No: D5951

Job Qty: 6 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/7/18

Job Tracking No:

Due Date: 4/12/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:E Re-Format 05-11-29 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		4/11/18	0.00	0.00	Start Up Machining-4		SBC 18/3/19
100	CNC Vertical Machining	6 pcs		4/11/18	0.54	18.18	HAAS1-1		SBC 18/03/19
110	QC	6 pcs		4/11/18	0.00	0.00	QC1		1/18
120	QC	6 pcs		4/11/18	0.00	0.00	QC8 Machining-4		18-03-27
130	HandFinish	6 pcs		4/11/18	0.00	0.46	HandFinish1		18-3-28
140	Powdercoat	6 pcs		4/12/18	0.00	0.32	Powdercoat1		18-3-28
150	QC	6 pcs		4/12/18	0.00	0.00	QC3		38
160	Packaging	6 pcs		4/12/18	0.00	0.00	Packaging3-2		DAS-89
170	QC21-SA	6 Ea		4/12/18	0.00	0.00	QC21		21

Part Op 100 - 1-Machine as per folio D5951, Ensure Batch Number is entered 2-Machine Keyway 3-Deburr & Tumble
Descriptions: 140 - START TIME: 11:50 C.V.T. 300° FINISH 12:20. M134760. APR 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-013	Saddle Billet	6 Ea (1 ea)	90-Start up Operation	

S017338 → S052487

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-013	6	24	0

Part Specifications

Specifications could not be found.

Plex 3/7/18 2:02 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
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Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 03/19/18

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐
OTHER :			



Container No: S052488



Part: D5951

Job No: 173832

Serial No/Batch: S052488

Revision:

Inspector:

Cut Too Short	☐	Mislabeled	☐	FINISH	☐
Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐

MAR 07 2018

SH
RE
ENC
DART

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

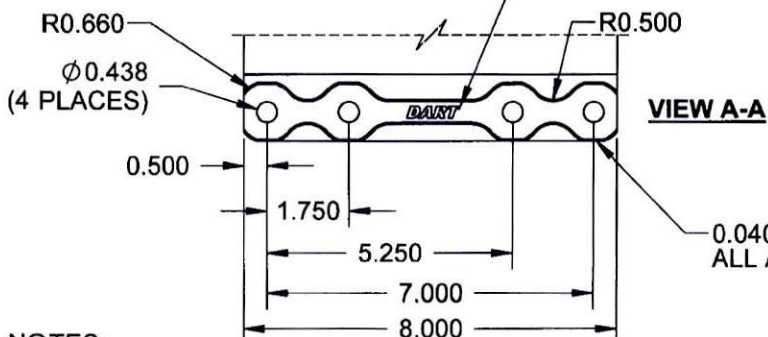
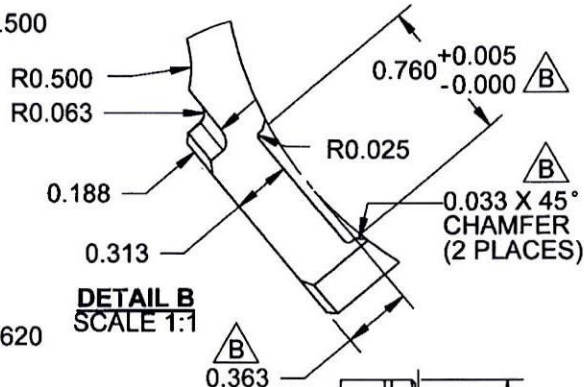
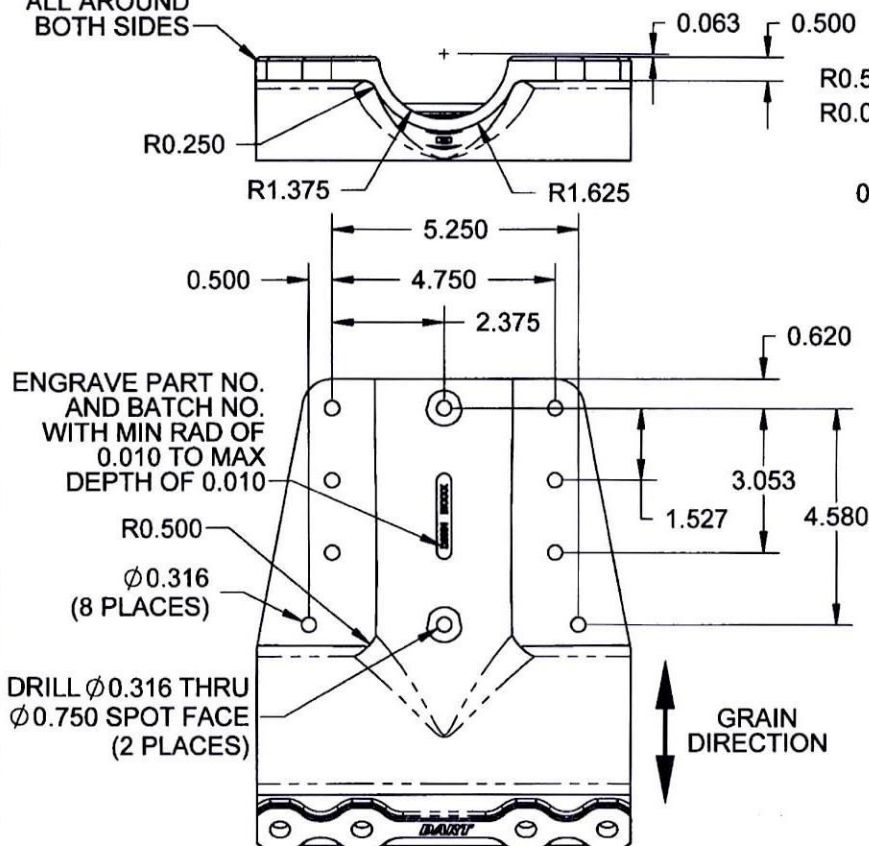
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D5951	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER FWD SADDLE SCALE 1:4		
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;	

WITHOUT NOTICE
WORK ORDER

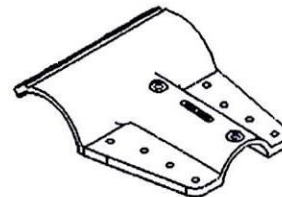
NO. 173832

CHAMFER
0.075 X 45°
ALL AROUND
BOTH SIDES

06.11.28 **[Signature]**

**D5951 OUTER FWD SADDLE****NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12 (MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020



ISOMETRIC VIEW
SCALE 1:8

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DART AEROSPACE LTD		Work Order: 173832
Description: Outer Fwd Saddle		Part Number: D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.437	0.444		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	6.997	6.997	6.997		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.316	0.316	0.316	0.316		
H	1.522	1.532		1.528	1.527	1.527	1.528		
I	3.048	3.058		3.054	3.053	3.053	3.054		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.316	0.316	0.316	0.316		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.503	0.502	0.502	0.503		
N	1.615	1.635		1.625	1.625	1.625	1.625		
O	7.990	8.010		8.002	8.002	8.002	8.002		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.311	0.311	0.311	0.311		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.502	0.502	0.502	0.501		
T	1.375	1.395		1.375	1.375	1.375	1.375		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SBL
Date: 18/03/19

Audited by: A.F.
Date: 18-03-21

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

DART AEROSPACE LTD		Work Order: 173832
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C	5.245	5.255		5.245	5.245				
D	6.995	7.005		7.000	7.000				
E	5.240	5.260		5.250	5.250				
F	4.745	4.755		4.750	4.750				
G	0.315	0.322		0.316	0.316				
H	1.522	1.532		1.527	1.527				
I	3.048	3.058		3.053	3.053				
J	4.575	4.585		4.580	4.580				
K	0.315	0.322		0.316	0.316				
L	0.495	0.505		0.500	0.500				
M	0.490	0.510		0.502	0.5035				
N	1.615	1.635		R1.625	R1.625				
O	7.990	8.010		8.000	8.000				
P	2.240	2.260		R2.250	R2.250				
Q	0.307	0.312		0.313	0.311				
R	0.760	0.765		0.760	0.761				
S	0.490	0.510		0.4985	0.5005				
T	1.375	1.395		R1.375	R1.375				
U	2.000	2.020		R2.000	R2.000				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SBL
Date: 18/03/19

Audited by: h.e
Date: 18-03-27

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
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